108945

Page 1

October-30-13 7:37:08 AM D2275 Item ID: Accept *N900040100* Setup Start Revision ID: Stop Bushing *NS2* Item Name: **Start Oty: 20.00** *20* Start Date: 10/30/13 Cust Item ID: Required Date: 11/25/13 Req'd Oty: 20.00 *20* Customer: Reference: Start Run Date: 13-10-30 Tooling: Approvals: Process Plan: ML5 Date: Stop Date: QC: SPC (Y/N): Date: _____ Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description Number Stamp **Run Hours** Code Oty Oty Draw Nbr **Revision Nbr** D2275 Rev C 0.00 Hardinge CNC LATHE SMALL 20 Ø *1/00* 0AS \ 40 9-89 0.00 Hardinge 13/11/12 Memo Hardinge CNC Lathe Small Machine as per Folio FA 213 Tumble & deburr all sharp edges QC2- Inspect parts off machine FAI/FAIB 0.00 13/11/12 20 Ø *110* 0.00 OC Memo Quality Control 0.00 OC8- Inspect parts - second check 13/11/12 20 _ ø *120* 0.00 Memo Quality Control

DQA:		_ Date:			•								•	
		5.4			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		–				AEROSPACE
QA Closed:		Date:	_				1			Nork C	rder u	pdate only		
Work Orde	er:				DISPOSITION				AGAINST [DEPAR	IMENT	/PROCESS		:
				_	Rework	l		Skid-tube	Crosstube	\neg		Water Jet		Engineering
Part N	lo.				Scrap			Machining	Small Fab	_	Pro	d. Eng. Coor.	Н	Quality
				_	Use-as-is		1	noforming	Finishing	⊢ R		re/Packaging	П	Other
NCR N	10.				Suspected Unapproved		Large Fab Composite			Supplier			-	
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Root				Descr	ription of work order update	1	nitial	Actio	n	Si	gn &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	[Date	Verification	n	QC Inspector
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Equip/Tooling													}	;
Handling/Pre										,				
Material														
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Process														;
Supplier								<u>:</u>						
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Landii					General		1 /_		Г	_		1	$\overline{}$	
	_			<u> </u>	Bend BOM (B	<u> </u>	1	Program	-	_		nensions		Pressure/Forced
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		: (. //	\vdash	Broken/Damage/Defect	<u> </u>	Hardwa				Incorre		\vdash	Temperature/Cure
ŀ		ink/kippie	e/wave	\vdash	Burrs	<u> </u>	i '	ion Incomplete/Unq	⊢	— i	Lost/Mi	issing	\vdash	Weld
_	 i	_		\vdash	Countamination	<u> </u>	ł	tions Incomplete/Un	clear	⊣	Moved	i	Ш`	Wrong Stock Pulled
ν.		-		\vdash	Countersink	_	•	gned/off center	-		tioned V	· ·		0.1
			Tubo		Cut Too Short	_	Mislabe		L	Pow	er Loss/	Surge	Ш'	Other
			rupe	\vdash	Drawing Drill Holes	\vdash	Misread							
	Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				Finish	\vdash	Off-set							
	Cause Date Step Qty gn /Data p/Tooling dling/Pre erial rator et/Setup ess olier ning sport pproved Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter			\mathbb{H}	Fit/Function	\vdash	1	Calibration						

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Work Order ID 108945 *108945* Page 2 October-30-13 7:37:08 AM Item ID: D2275 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Bushing *20* 10/30/13 **Start Oty: 20.00** Start Date: **Cust Item ID:** Required Date: 11/25/13 Req'd Qty: 20.00 *20* **Customer:** Reference: Run Start Process Plan: Date: Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence 1D/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID **Description** Qty Qty **Run Hours** Code Number Stamp Identify as per dwg & Stock Location: 57 W603 130 0.00 DAS *120* 20 33 13-11-13 0.00 Packaging Memo Packaging *** STOCK IN STEP CELL***

QC21- Final Inspection - Work Order Release

0.00

140 OC

Memo **Quality Control**

0.00

DQA:		_ Date:												
					WORK ORDER NON	-C(ONFO	RMANCE / UF						AEROSPACE
QA Closed:		Date:		1						Wo	rk Order up	date only		
Work Orde	er:				DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS		
			•	_	Rework	1	Skid-tube Crosstube Water Jet					Engineering		
Part N	lo.				Scrap			Machining	Small Fab	—	Pro	d. Eng. Coor.	\dashv	Quality
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NCR N	10.				Suspected Unapproved	1		Large Fab	Composite	· —				
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Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption		Date	Verification	<u>1</u>	QC Inspector
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Material	\dashv				•									
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Landii	ng Gear				General									
	Bending				Bend		Folio/F	Program			Outside Dim	ensions		Pressure/Forced
	Centre N	lot Concei	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ct		Temperature/Cure
	Crimp/Ki	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	tions Incomplete/U	nclear		Part Moved			Wrong Stock Pulled
	Crushing				Countersink		┥	ned/off center			Positioned W	√rong		
	Heat Treat				Cut Too Short	_	Mislabe				Power Loss/	Surge		Other
		on Strip in	Tube	 	Drawing	L	Misread			_				
	Marks/C			<u> </u>	Drill Holes	L.	Off-set			_				
		Sequence		<u> </u>	Finish		-	Calibration		-				
	⊢ IWave/Tv	wist in Tub	oe -	- 1	Fit/Function	1	IOut of 9	Seguence						

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· Picklist Print

October-30-13 7:37:12 AM

Work Order ID: 108945

Parent Item:

D2275

108945 *D2275*

Parent Item Name: Bushing

Start Date: 10/30/13

Required Date: 11/25/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP E02.03.27Added in house machiningNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			100	f	36.3346	0.1667	4	SAC		
*M6061T6 6061 T6 Round Bar 1.250	R1 250	*							**		40	13/1	1/12

Location Loc Qty Loc Code MAT 36.3346 4,25 —⊅ m126593 36.3346

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U	PDATE	W	ork Order up	ndate only		AEROSPACE	
						DISPOSITION				AGAINST		PARTMENT				
Work Orde	er: _					0.51 05111014	.		<u></u>	AGAIIIST		· AINTIVIEITI	, r ROCESS			
						Rework			Skid-tube	Crosstube			Water Jet		Engineering	
Part N	۱o					Scrap			Machining	Small Fab	⊢—	4	d. Eng. Coor.		Quality	
						Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging	_	Other	
NCR N	No					Suspected Unapproved			Large Fab	Composite	L		Supplier			
Root					Desci	ription of work order update		Initial	Act	tion	-	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	n	QC Inspector	
Design									-							
Doc/Data			,										•			
Equip/Tooling	Ш															
Handling/Pre																
Material																
Operator																
Offset/Setup	Щ													i		
Process	Ш															
Supplier	Щ															
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Unapproved																
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Landi				*	_	General	_				_	7	,		•	
	\vdash	Bending	_		_	Bend	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	1	rogram		<u> </u>	Outside Dim			Pressure/Forced	
	\vdash	entre No	ot Concer	ntric	-	BOM/Route		Grain			L	Over/Under		<u>—</u>	Set-up	
	—	cracks			-	Broken/Damage/Defect	<u> </u>	Hardwa			<u> </u>	Part Incorred		—	Temperature/Cure	
	\vdash	rimp/Kir	ik/Ripple	:/Wave	<u> </u>	Burrs	L	1	on Incomplete/Ur	•	_	Part Lost/Mi	ssing	<u> </u>	Weld	
	\vdash	Cuffs			-	Contamination	<u> </u>	i	ions Incomplete/l	Jnclear	L	Part Moved	Į		Wrong Stock Pulled	
	\vdash	rushing			\vdash	Countersink	_	1 ~	ned/off center		_	Positioned V	· .	_		
		leat Trea		- .	<u> </u>	Cut Too Short	_	Mislabe			_	Power Loss/	Surge	<u> </u>	Other	
	_	nspection	-	Tube	\vdash	Drawing		Misread	İ							
	\vdash	Marks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set								
		urning S	•		<u> </u>	Finish	\vdash	4	Calibration							
	1 IV	Nave/Tw	ist in Tub	16	i	Fit/Function	l l	I Out of S	Coguenco							

DART AEROSPACE LTD	Work Order:	108945
Description: Bushing	Part Number:	D2275
Inspection Dwg: D2275 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
-	1.975	+/-0.010	1,974			VERN	P40-12
	1.500	+/-0.010	1,500			1,	1
+ .010	Ø0.750	+0.008/-0.001	.749			l.	٤.
•	0.10 x 45°	+0.030 x 0.5°	. 100			11,	1.
	Ø0.257	+0.006/-0.001	.257			H	1
	1.25	+/-0.030	1 245			, \	••
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		/ DAS					

Measured by: Audited by: Audited by: Date: 13/11/12

Audited by: Date: 13/11/12

Audited by: Date: N/A

Date: 13/11/12

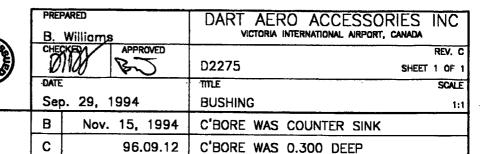
Date: N/A

Rev	Date	Change	Revised by	Approv ∉ d	i
Α	06.09.19	New Issue	KJ/JLM KJ/		
		· · · · · · · · · · · · · · · · · · ·	- 1		

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		ork Order up	odate only	AEROSPACE			
Work Orde	· - ·					DISPOSITION					PARTMENT					
WORK Orde	er: _					D = = #l.	1			7	\\\\-\-\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	, , , , , ,				
Part N	lo.					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Bro	Water Jet d. Eng. Coor.	Engineering Quality			
T dit i	•••				_	Use-as-is			noforming	Finishing	-	e/Packaging	Other			
NCR N	۱o			- 1		Suspected Unapproved		men	Large Fab	Composite		Supplier				
Root					Desci	ription of work order update		nitial	Act	tion	Sign &					
Cause		Date	Sten	Otv	Desci	or non-conformance		ief Eng	1	ription	Date	ು Verification	QC Inspector			
Design			Step	αι,		or non-comornance		inci, Eing	Deser	ripition	Dute	Vernicution	QC IIISPECTOR			
Doc/Data						·										
Equip/Tooling																
Handling/Pre																
Material																
Operator																
Offset/Setup																
Process							-									
Supplier																
Training																
Transport																
Unapproved																
							FAI	ULT CA	TEGORY		. •		•			
Landi	ng G	ear				General					,	•				
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced			
		Centre No	ot Concer	ntric		BOM/Route		Grain		·	Over/Under	tolerance	Set-up			
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct 🗌	Temperature/Cure			
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld			
		Cuffs				Contamination		Instruct	tions Incomplete/l	Unclear	Part Moved		Wrong Stock Pulled			
	NCR No. Date Step Qty Data Tooling Data Tooling Data Tooling Data Tooling Data				Countersink]Misalig	gned/off center		Positioned V		_				
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other			
		Inspection	n Strip in	Tube		Drawing		Misread	d							
		Marks/Ch	atter			Drill Holes		Off-set		•						
		Turning S	equence			Finish		Out of	Calibration							
	Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					Fit/Function		Out of	Sequence							

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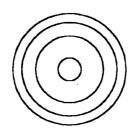


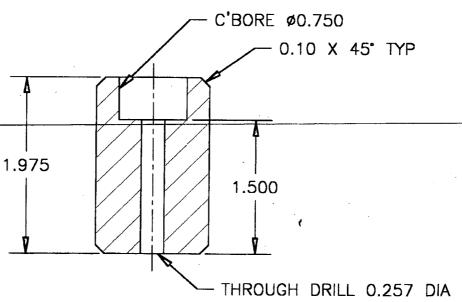
DELEASED 1960912 BD

UNDER REVIEW

DESIGNOK, BUT CHECK WITH DRY BEFORE MANDFACTYRE

OK P11.08.17





13-10-30 13-10-30

MATERIAL: 6061-T6 1.25 BAR STOCK (QQ-A-200/8)

DQA:		. Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:		Date:			WORK ORDER NON-	-CON	FORIVIANCE / C		ork Order u	pdate only	AEROSPACE			
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS				
Part No					Rework Scrap Use-as-is Suspected Unapproved	TH	Skid-tube Machining nermoforming Large Fab	Crosstube Small Fab Finishing Composite	-;	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root				Desc	ription of work order update	Initi	al A	ction	Sign &]				
Cause	Date	Date Step Qty			or non-conformance	Chief	Eng Des	cription	Date	Verification	QC Inspector			
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	4						CATECORY							
Landin						FAULI	CATEGORY							
Landin	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	Gra Hai Ins Ins Mi Mis Off	io/Program ain rdware pection Incomplete/l tructions Incomplete saligned/off center slabeled sread -set t of Calibration	/Unclear	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V	tolerance ct issing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other			
	□ Wave/Tw	ist in Tub	ne .		Fit/Function	Поп	t of Sequence							